

Date: Thursday, 20/11/2008 3:34:16 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT FRAME ASSEMBLY
Job Number : 43600	
Estimate Number : 11122	
P.O. Number :	Part Number : D3016041
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3016 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 43379	Material :
Written By :	Due Date : 20/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08-11-21</u>	
Comment : Est. A 01.09.19 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s)
 4130 Tube .750 OD x.049W
 Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall
 Batch: 111105

EL 9-2-25

2.0	M4130NT1000W120	4130 RD Tube 1.00 x .120wall
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Comment: Qty.: 1.5750 f(s)/Unit Total : 1.5750 f(s)
 4130 Tube 1.0"D X 0.120"W
 batch: 1109534

EL 9-2-25

3.0	M4130NT0500W049	4130 RD Tube .500 x.049W
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Comment: Qty.: 4.5150 f(s)/Unit Total : 4.5150 f(s)
 4130 Tube .500 OD x.049W
 Cut- AISI 4130N tube, Ø1/2" x 0.049" wall
 Batch: 11106651

EL 9-2-25

4.0	D301617	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Gusset
 Pick:

Qty	Part Number	Description	Batch
2	D3016-17	Gusset	<u>B391641</u>

EL 9-2-25 K.8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43600

Part Number: D3016041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D301613	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bracket

Pick:

Qty	Part Number	Description	Batch
2	D3016-13	Bracket	B34208

EL 9-2-25 X2

6.0	D301615	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Gusset

Pick:

Qty	Part Number	Description	Batch
2	D3016-15	Gusset	B43413

EL 9-2-25 X2

7.0	D30201	Fitting
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Fitting

Pick:

Qty	Part Number	Description	Batch
4	D3020-1	Fitting	B36713

EL 9-2-25 X4

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M100075

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

EL 9-2-25

9.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

BE 09-2-25

Pto

278597

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3016-041 PAR #: N/A Fault Category: Prod / FAB.assy. Large NCR: Yes No DQA: AD Date: 09/03/03
 Resolution: D350-689-SCAP Disposition: SCAP QA: N/C Closed: AD Date: 09/03/03

NCR: <u>43600</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/20	80	Welder welded the assembly not bolted or tight in D3597. R.C. Lack of complete training and employee moves not fast with out asking	<i>[Signature]</i> <i>[Signature]</i>	SCAP and Destroy and Repair @	EZ 9-2-25	S 09/02/25	<i>[Signature]</i> 09/2/25	S 09/01/25
				D3016-9/11 m108532@ 75/8" D3016-5/7/7 m100651@ 25"	EL 9-2-25	S 09/01/25		S 09/01/25
				D3016-1/3/3 m11105@ 25"	EL 9-1-20	S 09/01/25		S 09/01/25

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation: Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/02/25 @

11.0

POWDER COATING

POWDER COATING



12109648



Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

MF 09-02-26

(X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-02-26

(1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

CP 09/02/26 @

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



MF 09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

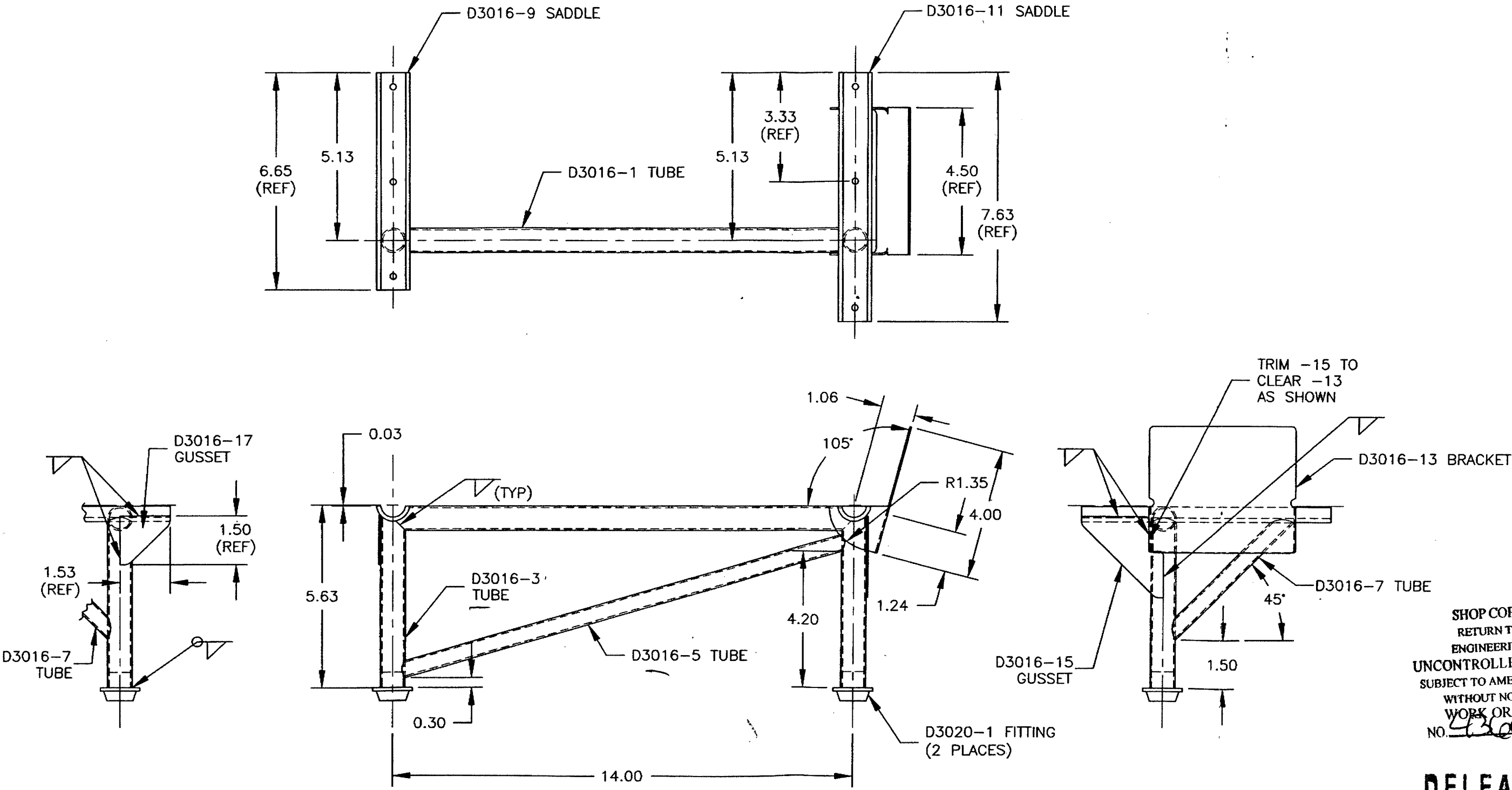
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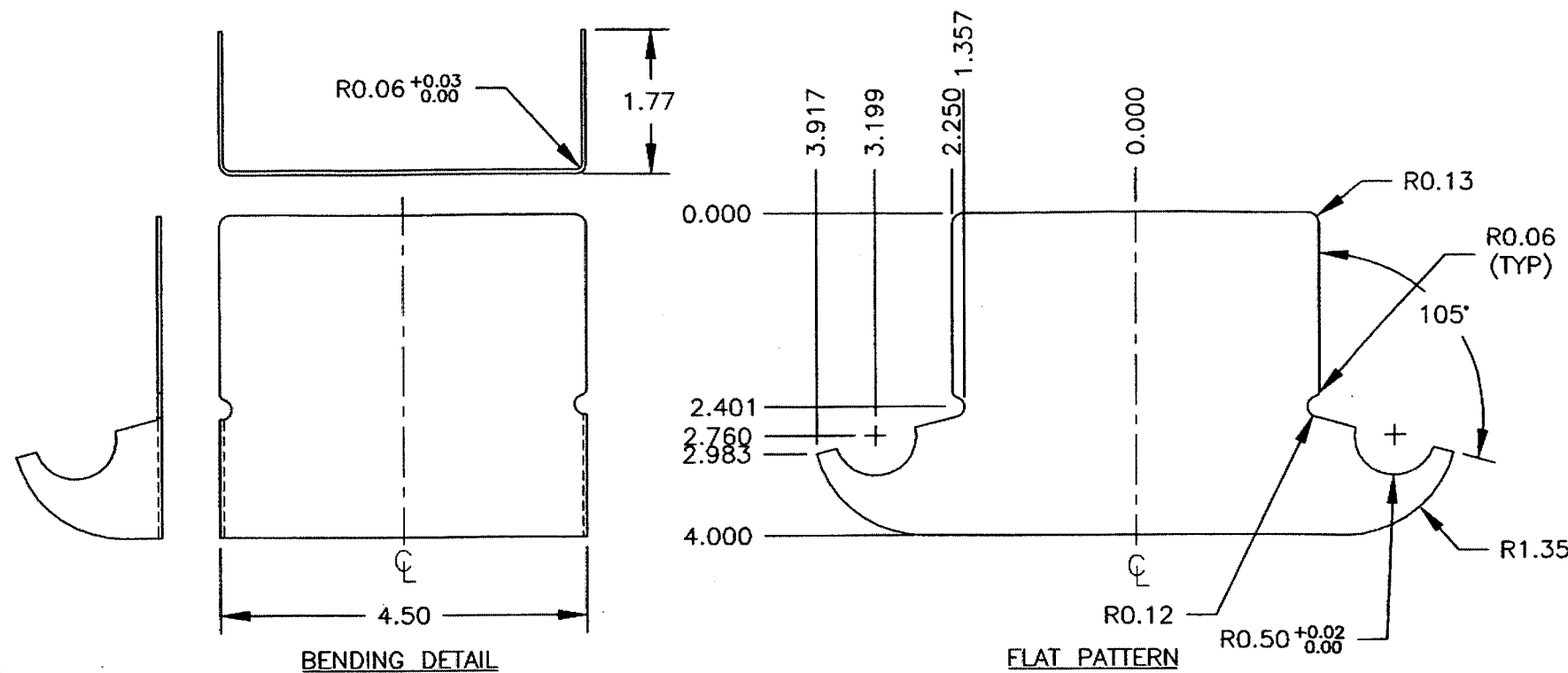
D3016-041 SEAT FRAME ASSEMBLY



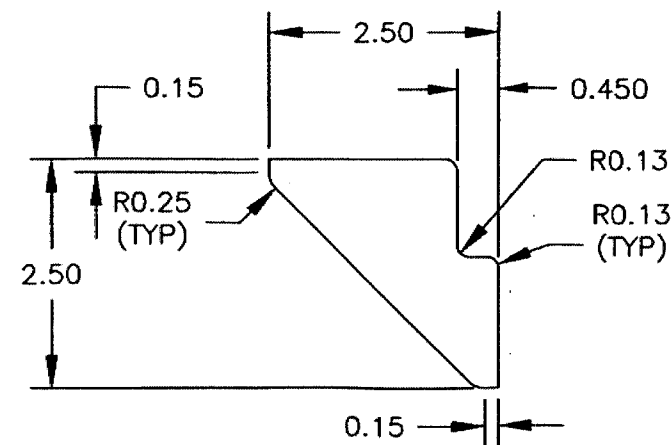
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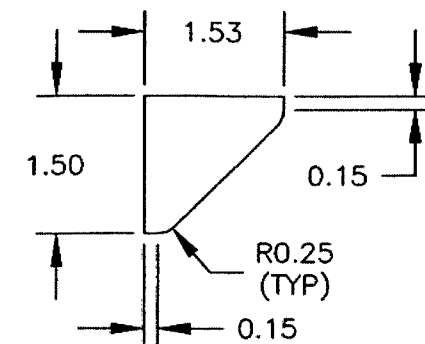
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	CHECKED #	APPROVED #			SHEET 2 OF 3
	DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY			SCALE 1:3



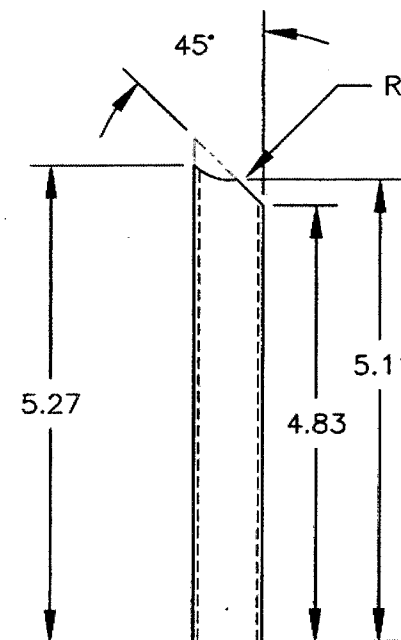
D3016-13 BRACKET



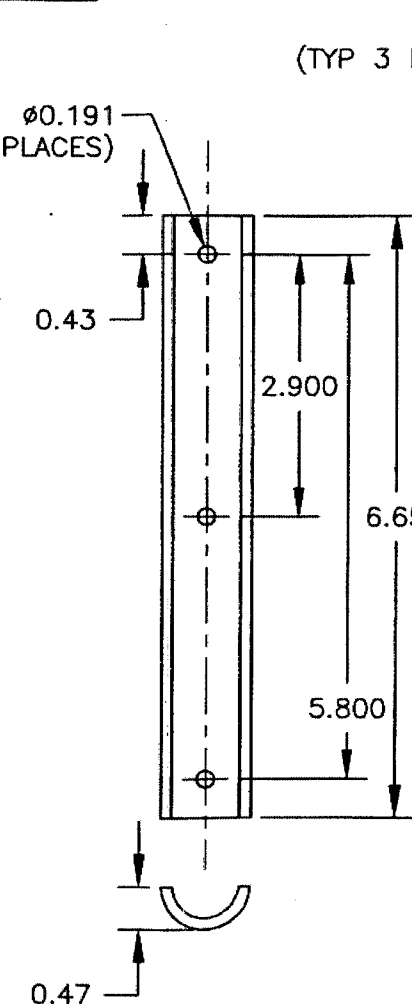
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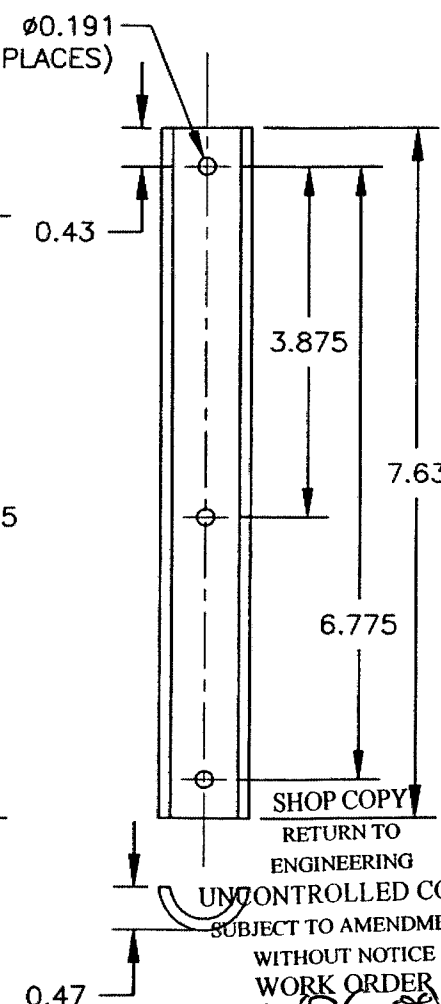
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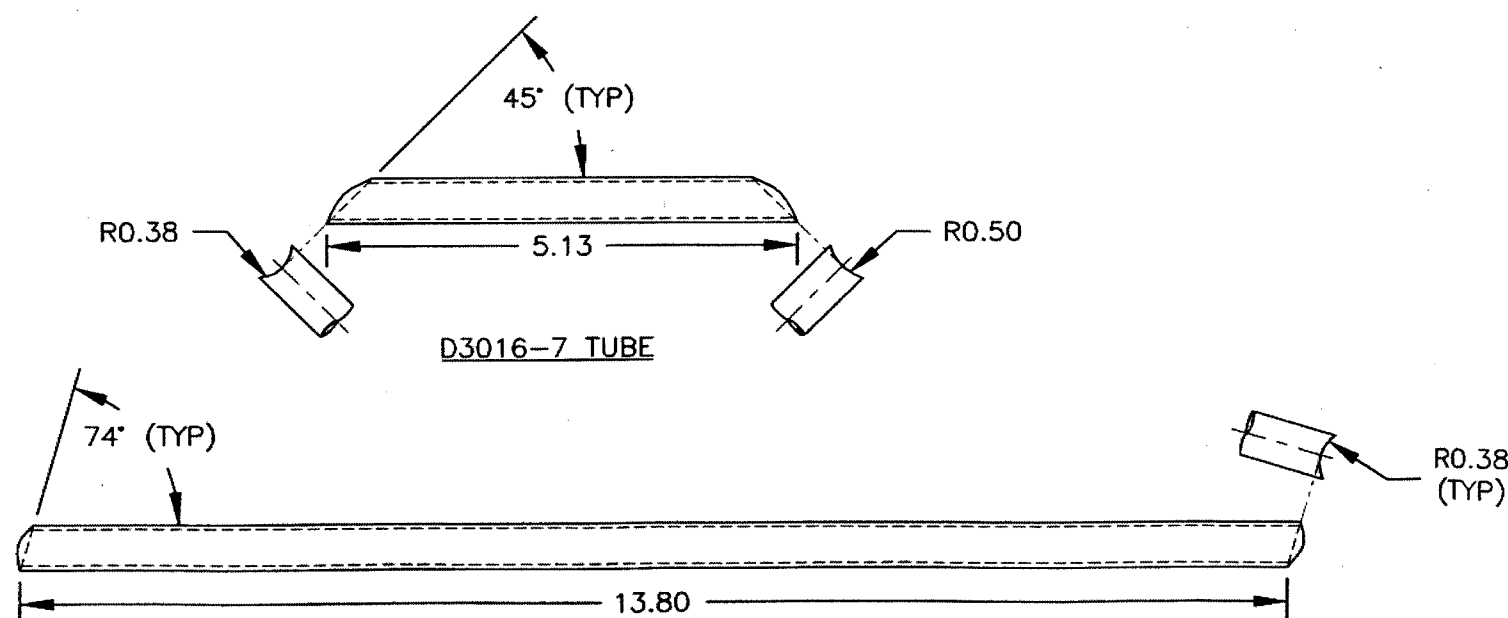
D3016-3 TUBE



D3016-9 SADDLE

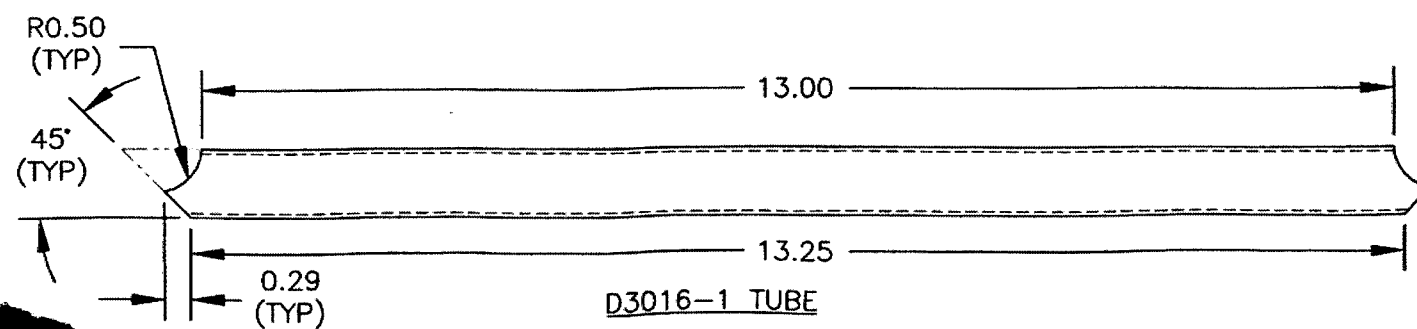


D3016-11 SADDLE



D3016-7 TUBE

D3016-5 TUBE



D3016-1 TUBE

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DATE		01.05.18		DRAWING NO.	REV. A
				D3016	SHEET 3 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:2